

Date: Thursday, 12/20/2007 3:17:30 PM
 User: Kim Johnston

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 36467A03
 Estimate Number : 10145
 P.O. Number : N/A Part Number : D2037101
 This Issue : 12/20/2007 S.O. No. : N/A Drawing Number : D2037 REV C3
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C3
 Previous Run : 36466A03 Material : N/A
 Due Date : 1/15/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : AD 12 21
 Comment : Est Rev: A New Issue 05-11-01 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 4.1118 f(s)/Unit Total : 16.4472 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)
 Batch: M106015x2 / M105988x1 FF 10-01-08 (4)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1 FF 10-01-08 (4)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037 FF 11-01-08 (4)

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required FF 14-01-08 (4)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP 08/06/15 (4)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 241A 8/1/15 (4x) SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/04/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARM

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

208/01/16

Job Completion



u 28-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

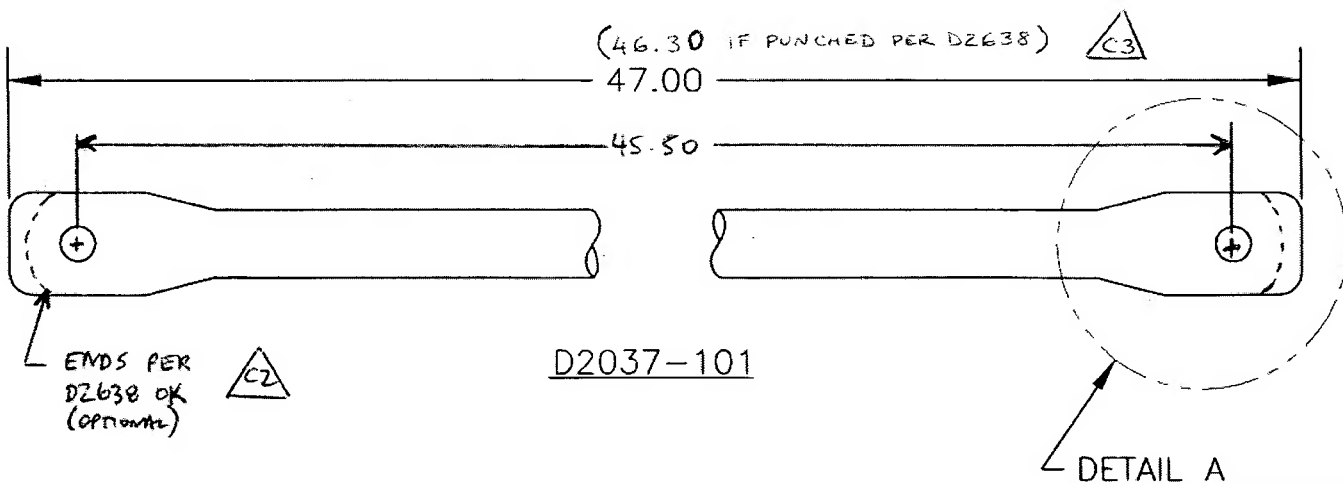
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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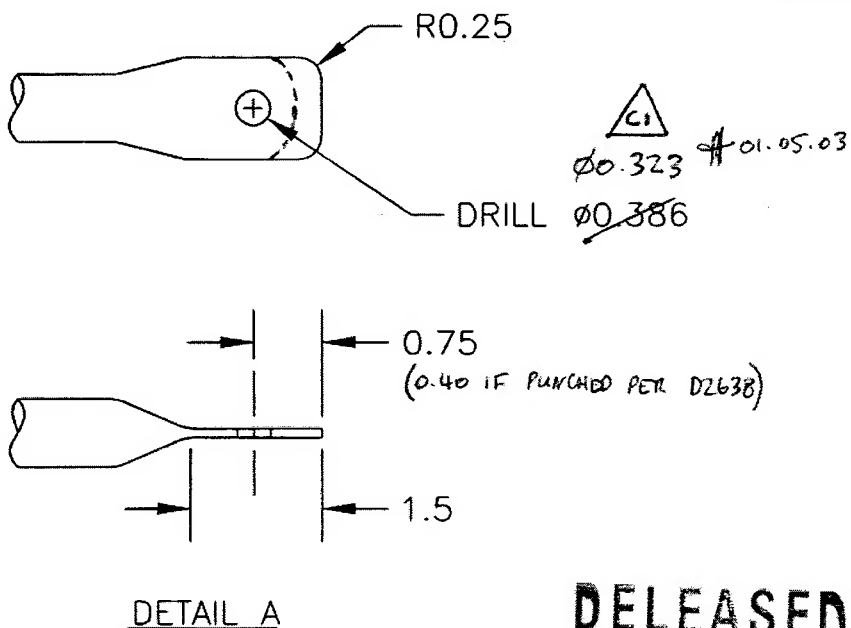
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
JB	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	[Signature]	D2037	
DATE	TITLE	SCALE	
99.06.07	ARM	NTS	
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1	01.05.03	CHANGE TO $\phi 0.323$	
C2	02.06.14	ADD PUNCH PER D2638 AS OPTION	



D2037-101

**RELEASED**
RE 99.06.10

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 36461A03

C3 05.04.27 ADD 46.30 PUNCHED PER D2638